GEARTECH	CHEC	KLIS	ST		No. CK8506		SHEET	1 OF 2		
SEARTESTI					Rev. A					
Inspection by Magnetic			BY RLE		DATE	11/06/01				
							11/06/01			
APPARATUS										
Question	Y	N	R		С	omments				
Are process equipment and										
materials in accordance with										
ASTM E 709 for wet particle										
technique?  Is magnetization technique v	/ot									
continuous magnetization?	VEL									
Is magnetizing current HW o	r									
Is direction of magnetization circular and longitudinal?										
For circular magnetization of										
hollow parts, does the currer										
pass through a conductor roo	b									
passing through the bore?										
Is inspection performed in a darkened enclosure?										
Is the black light in accordan	ce									
with ASTM E 709?										
Is standardized test specime										
a gear or sector of gear teeth										
with known crack indications	?			COT OD	COMENIO					
Question	Υ	N	R	ES1 5P	ECIMENS	omments				
Are tests performed on parts		IN	K		C	omments				
after all grinding is complete										
and before any shot peening	?									
PROCEDURE										
Question	Y	N	R		С	omments				
Does test procedure conform to ASTM E 709?										
Is test procedure verified with	n a									
standardized test specimen										
before any inspection?  Is test procedure adjusted ar	nd									
verified until known indication are reproduced?										
Are strength and direction of										
magnetic field verified with a										
magnetic field indicator?										
Are 100% of all exterior										
surfaces inspected?										
Is process controlled so the	Ca									
part is not heated above 65° Are parts demagnetized afte										
inspection to 2 Gauss max?	'									
Are parts cleaned after										
inspection?										
INTERPRETATION OF RESULTS										
Question	Y	N	R		C	omments				
Are indications assessed and	d   c									
classified as surface or near										
surface discontinuities?										

GEARTECH CH	KLIS	ST		No. CK8506		SHEET 2 OF 2					
GEARTEUN					Rev. A						
Inspection by Magnetic Particle					BY RLE		DATE 11/06/01				
moposasm by magnetis i artisis					CKD JRM		DATE 11/06/01				
Question	Υ	N	R		0.12 0.111	Comments					
Are indications assessed and											
classified with respect to											
location, direction, frequency,											
and size?  ACCEPTANCE CRITERIA											
0 1				EPIANO	JE CRITERIA	0 1					
Question Are indications within the	Υ	N	R			Comments					
acceptable limit?											
REPORT											
Question	Υ	N	R	11	OITT	Comments					
Does the report include a		.,				Commonic					
record of indications showing											
location, direction, frequency,											
and size?											
Does the report include a											
record of magnetizing current (HW or FWDC)?											
Does the report include a											
record of magnetic current											
strength?											
Does the report include a											
record of verifications?											
Does the report include a record of calibrations?											
record of calibrations?											
							-				
	-	-	-	<b> </b>							